

Date: Monday, 4/30/2007 7:22:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 32097	
Estimate Number : 10298	
P.O. Number : N/A	Part Number : D25773
This Issue : 4/30/2007 S.O. No. : N/A	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 30551	Material : N/A
	Due Date : 5/20/2007
Written By : _____	Qty: 30 Um: Each
Checked & Approved By : <u>07.04.30</u>	
Comment : Est. F 02.09.24 Re-format; Incorporated D2577-101-13 K	
J/RF	
Est. C 06.07.21 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.9240 sf(s)/Unit Total : 27.7200 sf(s)

1010/1025/A21/6aA SHEET 0.063 thick

Batch: m104421 ml 07 05 16

(30)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut D2577-101 as per Dwg D2577

Dwg Rev: EProg Rev: Eml 07 05 16

(30)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

ml 07 05 16

(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

ml 07 05 22 (30)

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
DeburrJohn 07/05/23

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/30/2007 7:22:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32097

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

SB - 07/05/25 (30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LAOS-29 (30)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description
A/R 7560 Hardcoat Rod

Batch

M10/1221

FC 07/06/01 30

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/04 (30)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 10/1601

BR/EX. 07-06-04 (30)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/06/05 (30X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-18

M-1 07/06/05 (30X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/02

Job Completion



W. J. H. 06/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

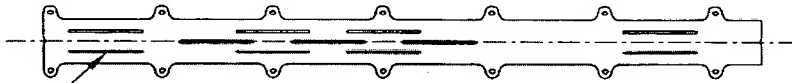
NOTE: Date & initial all entries



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00.09.22

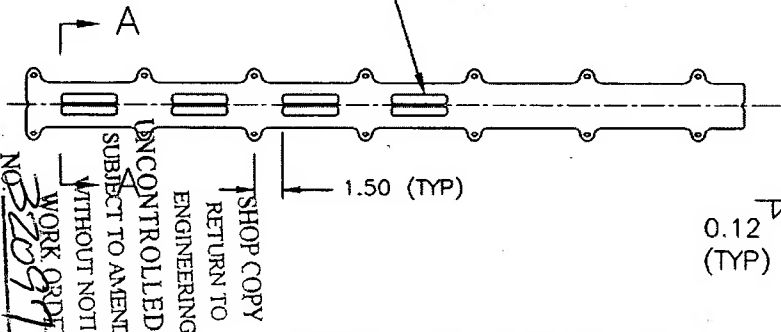
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 5
00.09.22	00.09.22	D2577	SCALE 1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

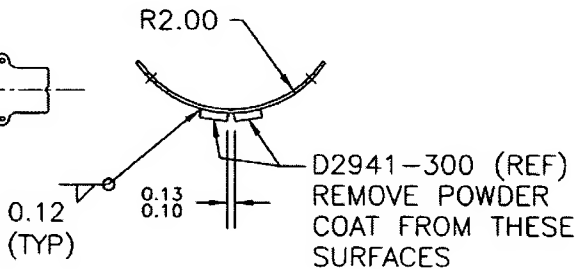


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



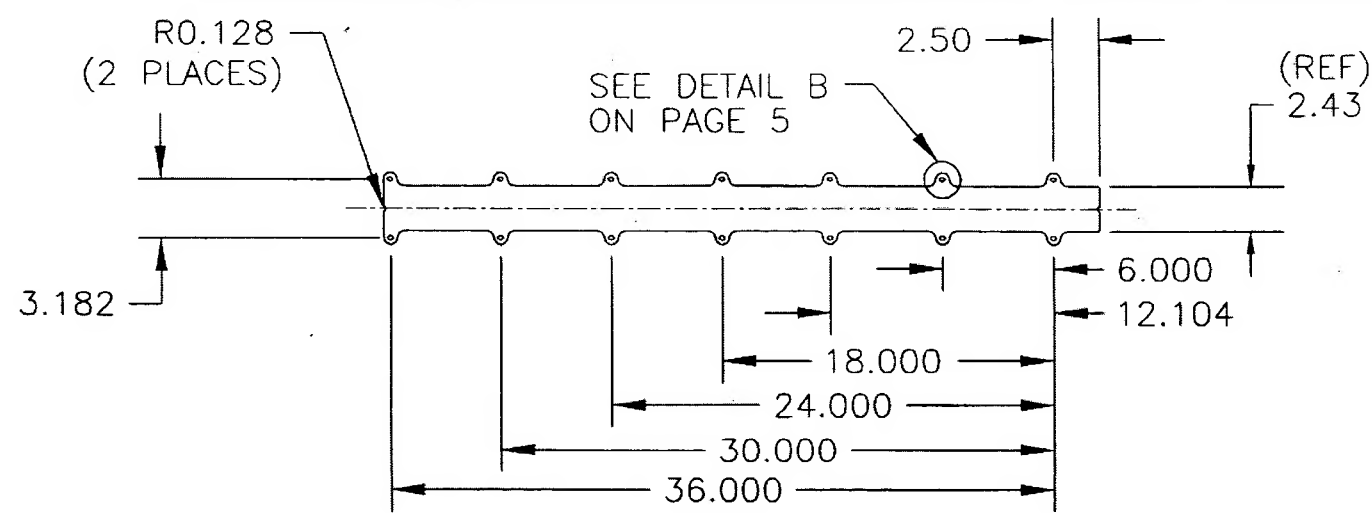
D2577-101 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DRAWING NO.	REV. E
<i>[Signature]</i>	<i>[Signature]</i>	D2577	
CHECKED	APPROVED	TITLE	SHEET 2 OF 5
<i>[Signature]</i>	<i>[Signature]</i>	WEARSHOE	SCALE 1:10
DATE			
00.09.22			

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HAWKESBURY, ONTARIO, CANADA

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00-09-26 #



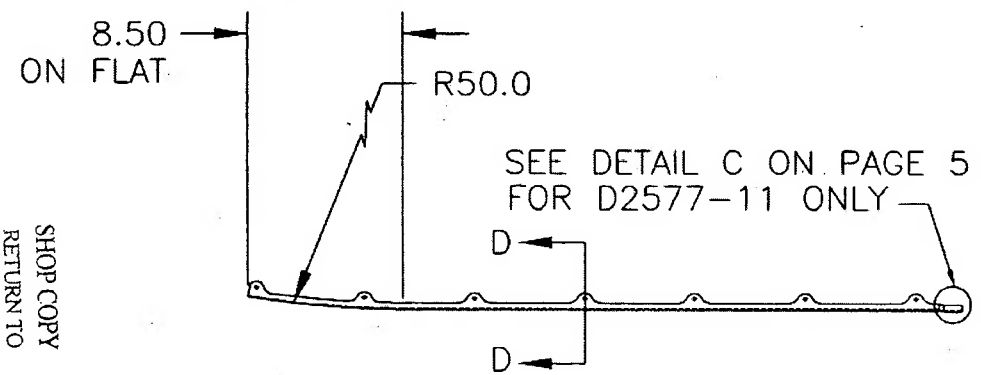
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 32097

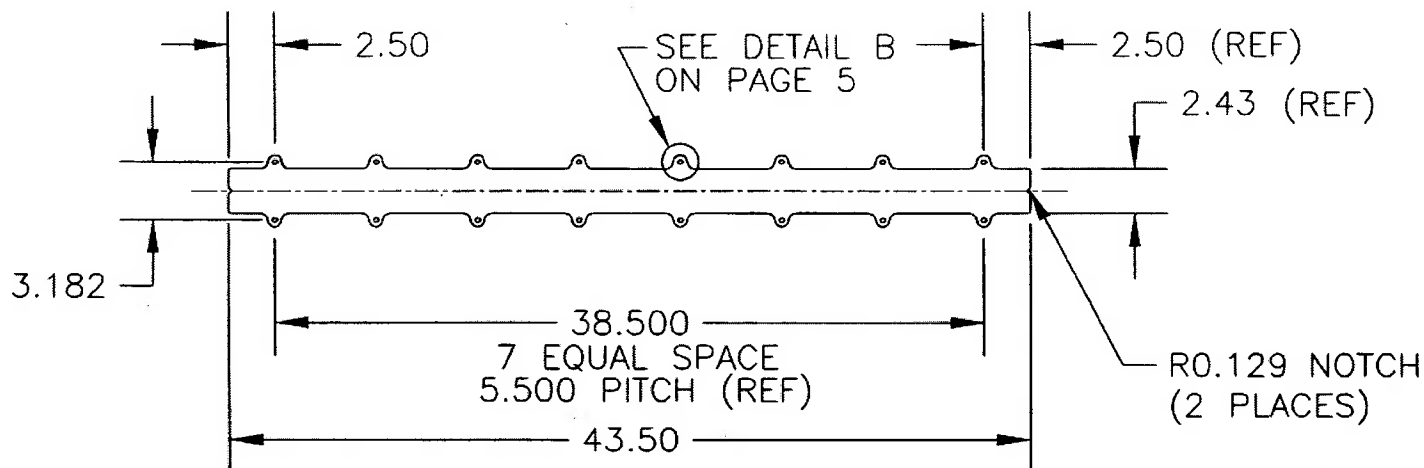
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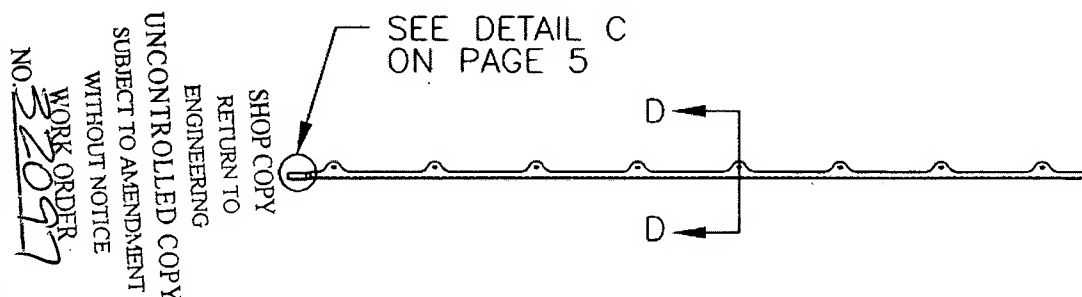
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CHECKED	APPROVED	DRAWING NO.
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	D2577
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 3 OF 5
		SCALE
		1:10

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00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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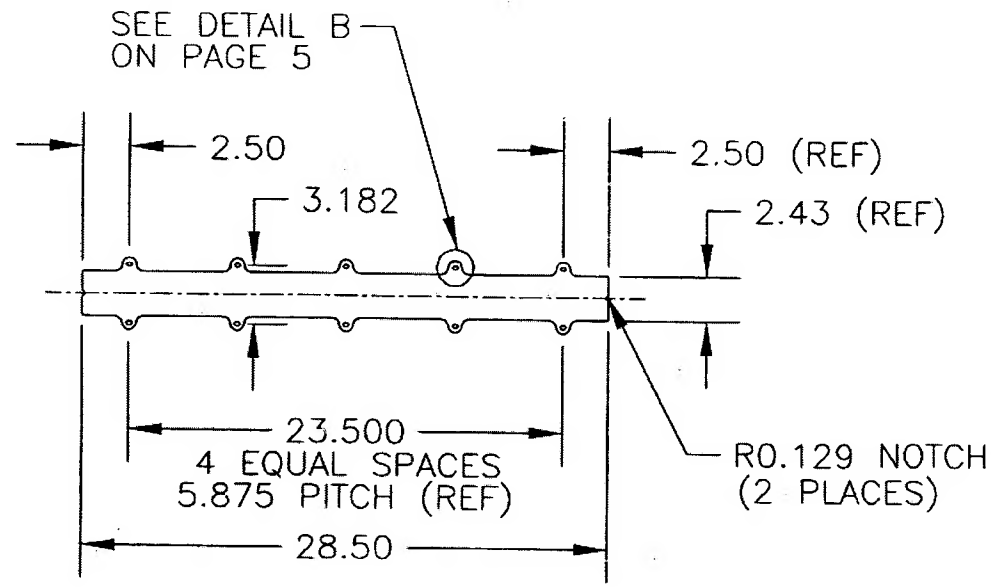
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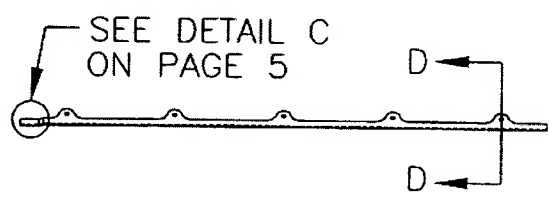
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CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22		TITLE WEARSHOE
		REV. E
		SHEET 4 OF 5
		SCALE 1:10

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D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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WORK ORDER
NO. 32097

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

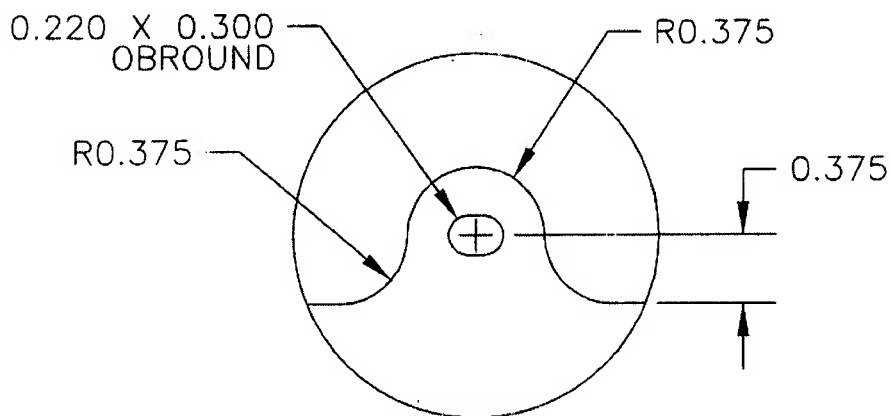
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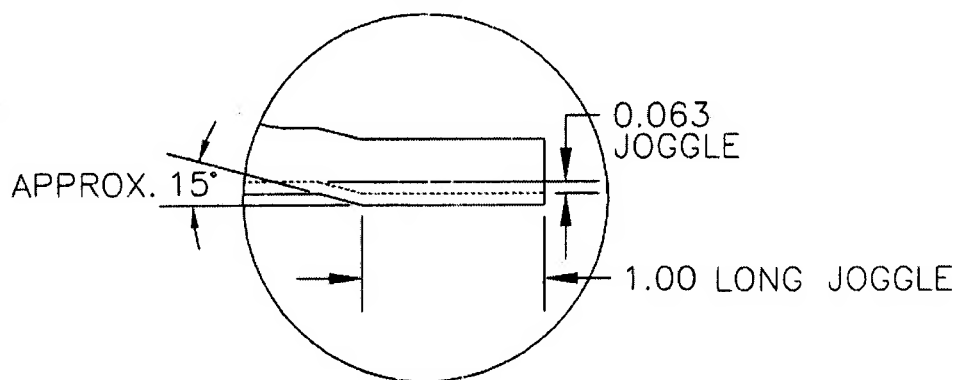
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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

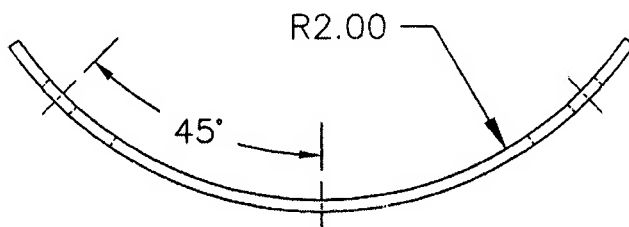
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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DART AEROSPACE LTD		Work Order: 32097
Description: Boat Wearplate		Part Number: D2577-3
Inspection Dwg: D2577 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	3.182	+/- 0.010	3.182	✓		vern	
B	2.43	+/- 0.030	2.437	✓		vern	
C	0.220x0.300	+/- 0.010	0.219x0.300	✓		vern	
D	36.000	+/- 0.010	36.000	✓		Measuring tape	
E	30.000	+/- 0.010	30.000	✓		Measuring tape	
F							
G							
H							
I							
J							
K							
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N							
O							
P							
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R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: <i>M. M</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07.05.16	Date: 07.05.16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

[Signature]